

Split

Work Order ID 91605-2

October-17-12 9:54:09 AM

91605

Page 1

Item ID: D2065

Accept

N900040100

Setup

Start

NS1

Revision ID:

(4) ~~803~~
4
4

Stop

NS2

Item Name: Arm

Start Date: 10/11/12 Start Qty: 4.00

Cust Item ID:

Required Date: 10/19/12 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan ✓
QC:

Date: Tooling: Date:
Date: SPC (Y/N): Date:

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2065	Rev C

100

100

Small Fab

Small Fab

Memo

cut at 19-75 62^b 0.00

Small Fab

1-Punch 1/2" OD x .049" Wall 304/316 SS as per Dwg D2065 (per D2727)
using DT8012.

Note: 1 end only

2-Cut to length as per Dwg D2065

3-Form as per Dwg D2065 and template DT8251

4-Drill 0.188" Dia holes as per Dwg D2065 using drill jig DT8779 and template

110

110

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

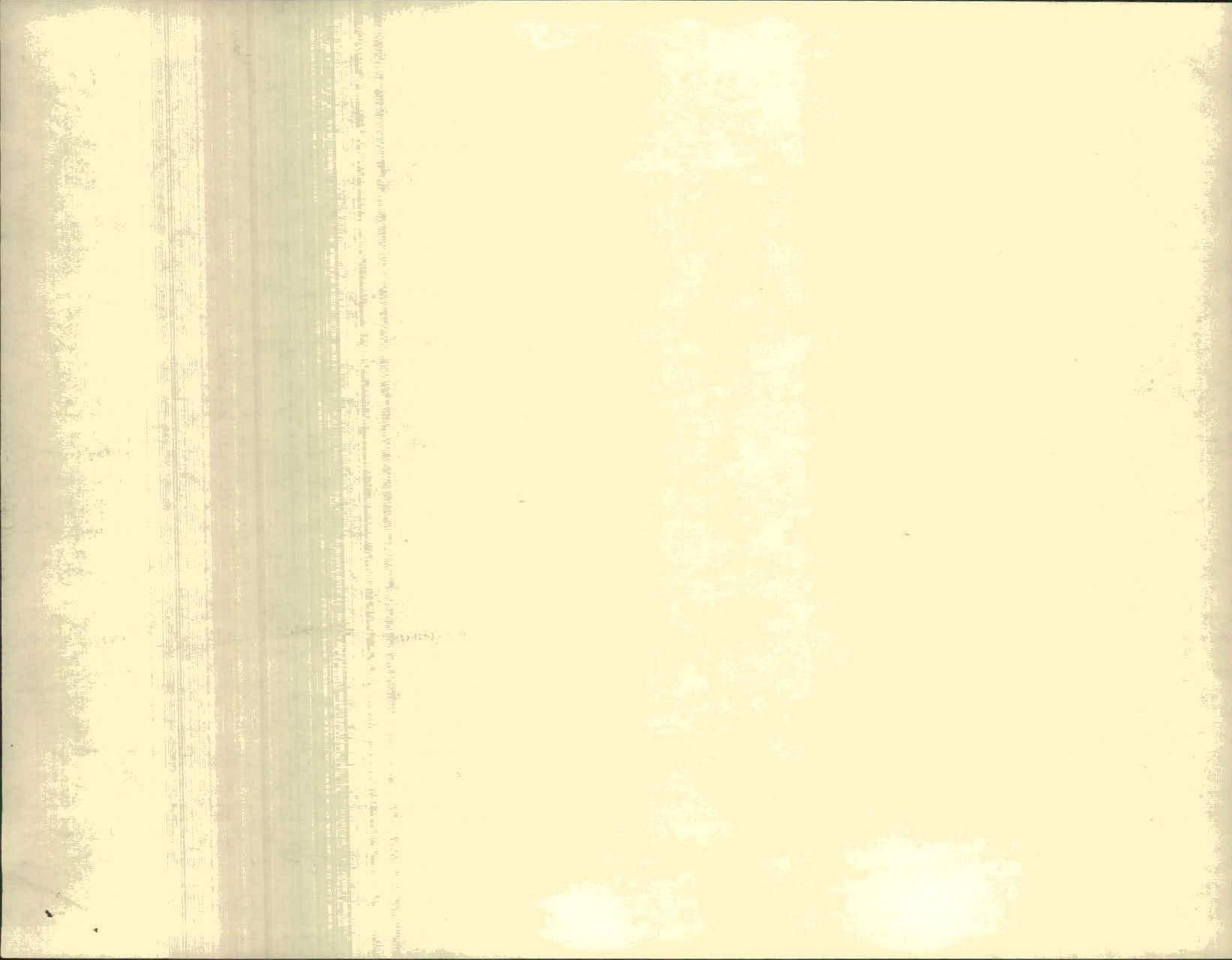
Spa
B12 19

8-9

FF
12-11-13

(3)

4



Work Order ID 91605

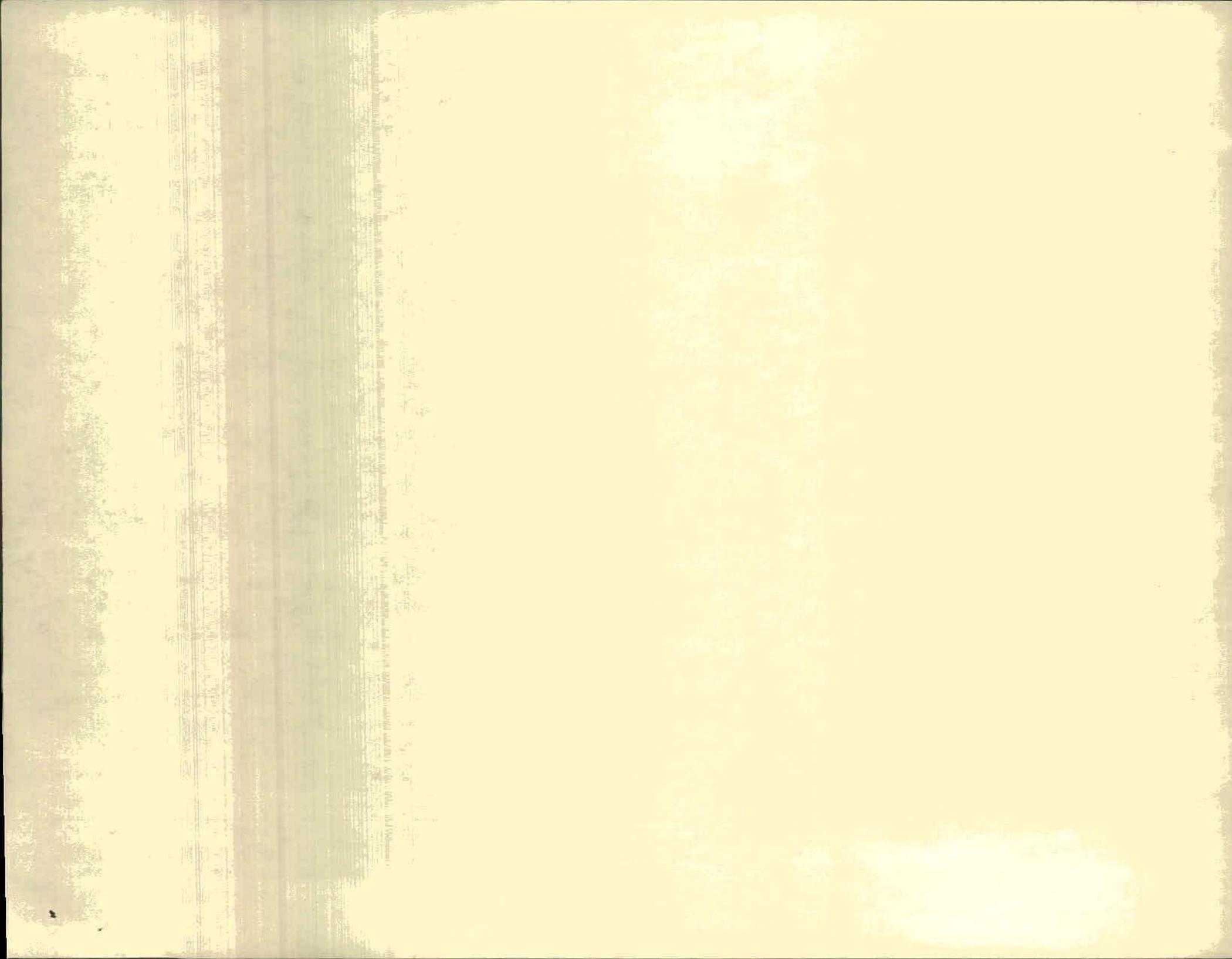
October-17-12 9:54:09 AM

91605

Page 2

Item ID:	D2065	Accept	*N900040100*	Setup	Start	*NS1*	
Revision ID:							
Item Name:	Arm					Stop *NS2*	
Start Date:	10/11/12	Start Qty: 4.00	*4*	Cust Item ID:			
Required Date:	10/19/12	Req'd Qty: 4.00	*4*	Customer:			
Reference:							
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 <i>M12079</i>	0.00							
	Memo START TIME: OVEN TEMPERATURE: FINISH TIME:	0.00 <i>8:40</i> <i>220</i> <i>9:10</i>							
	*****MASK OPEN END OF TUBING*****								
130 *130* QC Quality Control	QC3- Inspect Part Finish	0.00	<i>0As</i>	<i>15</i>	<i>0-89</i>				
	Memo	0.00	<i>12-12-20</i>						
140 *140* Packaging Packaging	Identify as per dwg & Stock Location <i>S1227</i>	0.00							
	Memo	0.00							



Work Order ID 91605

October-17-12 9:54:09 AM

91605

Page 3

Item ID: D2065

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Arm

Stop

NS2

Start Date: 10/11/12 Start Qty: 4.00

4

Cust Item ID:

Required Date: 10/19/12 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

150

QC

Quality Control

QC21- Final Inspection - Work Order Release

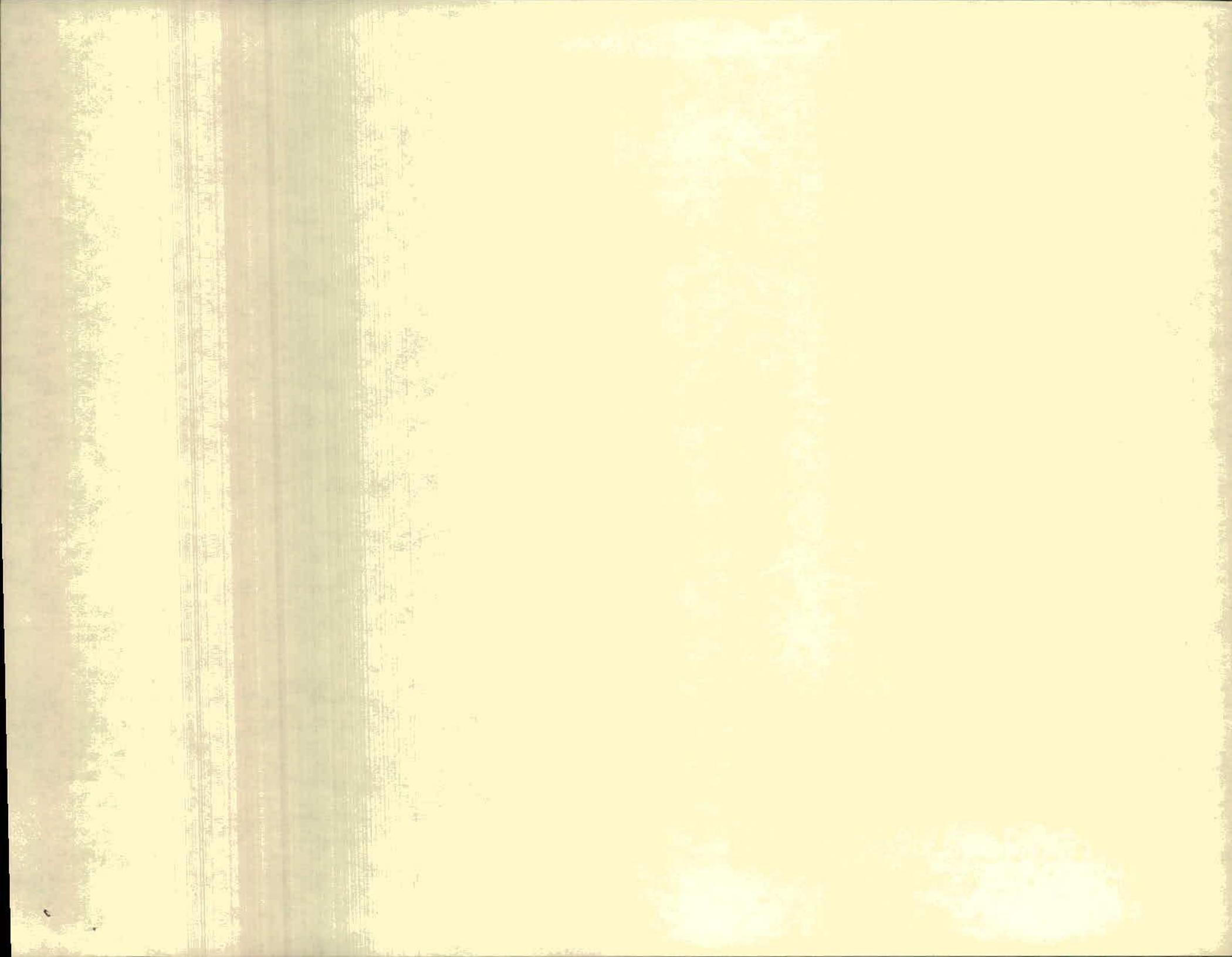
0.00

Memo

0.00

13/10/03

W 13-01-03



Picklist Print

October-17-12 1:43:04 PM

Page 1

Work Order ID: 91605

Parent Item: D2065

Start Date: 10/11/12

Required Date: 10/19/12

Parent Item Name: Arm

Start Qty: 4.00

Required Qty: 4.00

Comments: EPP: E02.04.15Added Dwg Rev.BING
IPP Rev:F 08-07-24 revC as per dwg (ecn 08-504) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TR0.500W.049 304 RD Tube .500 x .049W	Purchased	No				f		127.3311		6.8		SAD	12/11/08
--	-----------	----	--	--	--	---	--	----------	--	-----	--	-----	----------

Location	Loc Qty	Loc Code
MAT017	127.3311	
111814	2.23	
115010	109.254058	6.8
119087	7.359	
120633	8.488052	6.8
M/233#3		6.8
		1.7



8 7 6 5 4 3 2 1

D

D

C

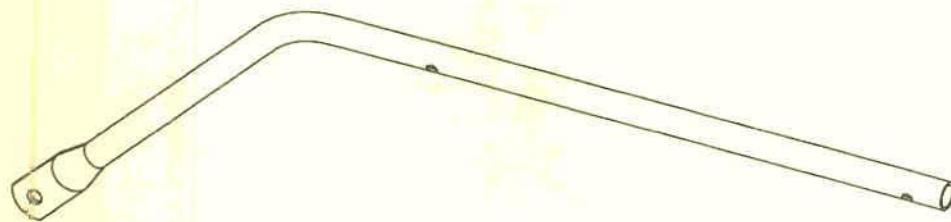
C

B

B

A

A

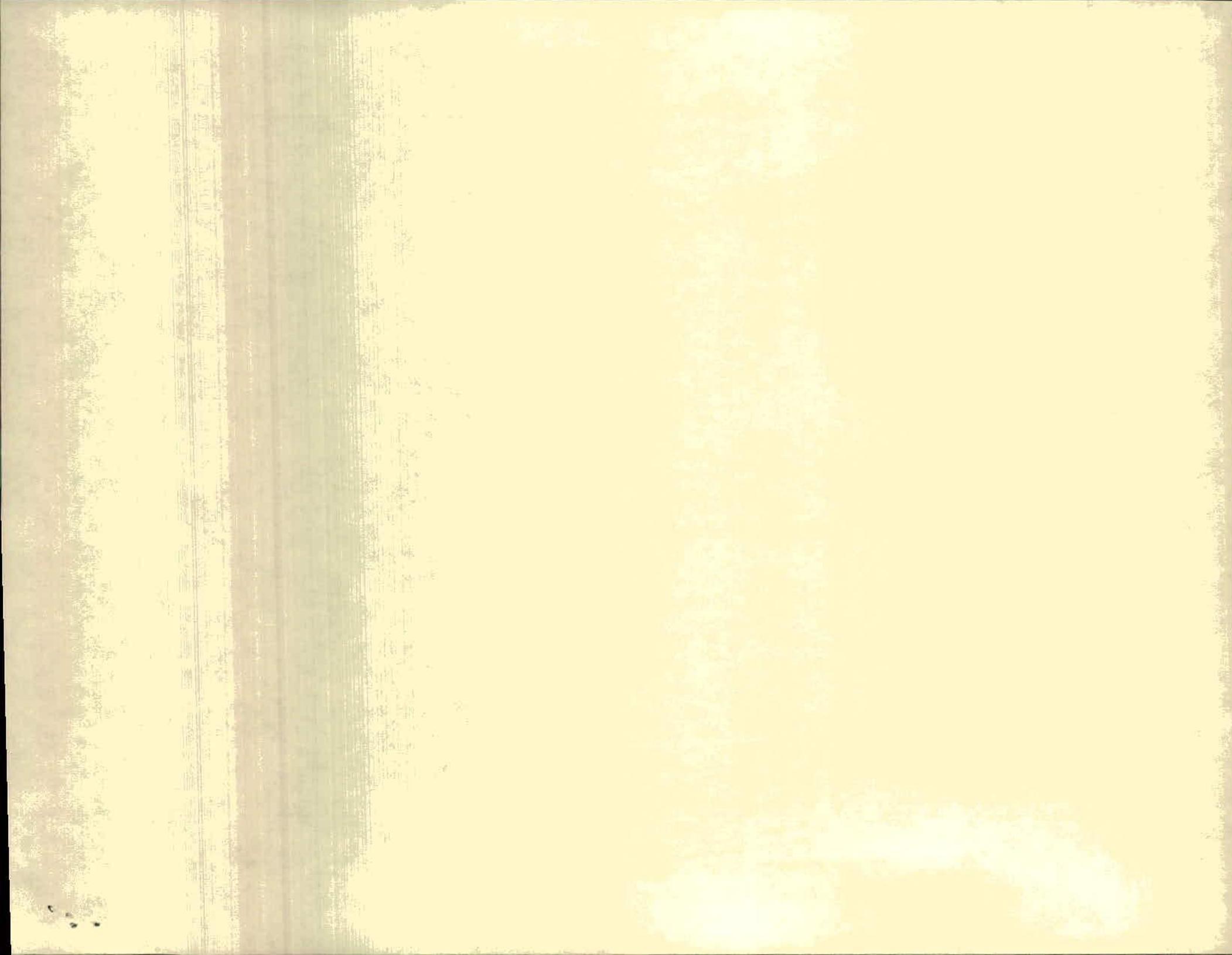


D2065 ARM

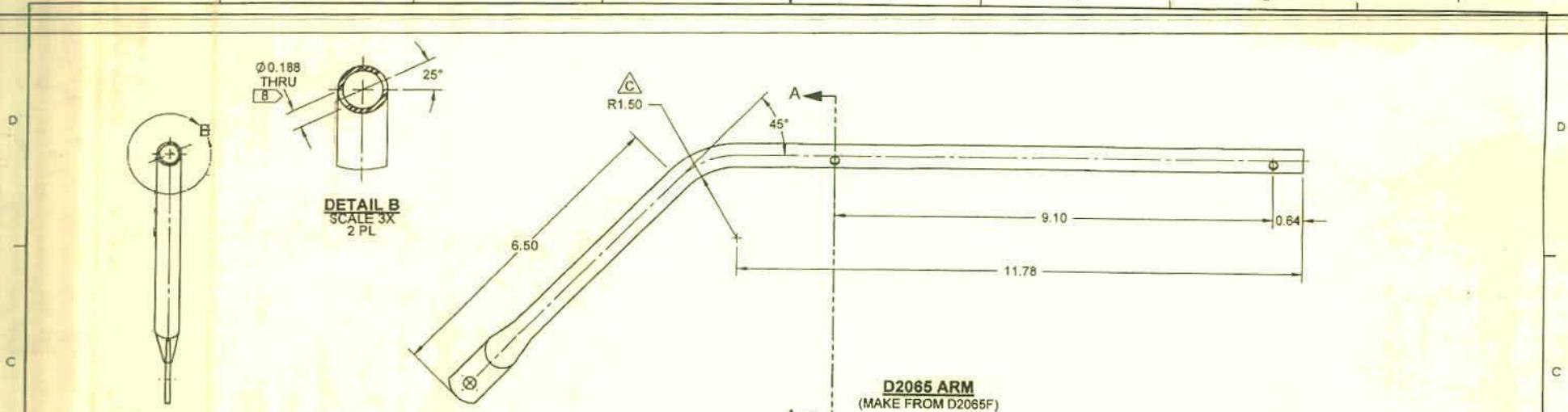
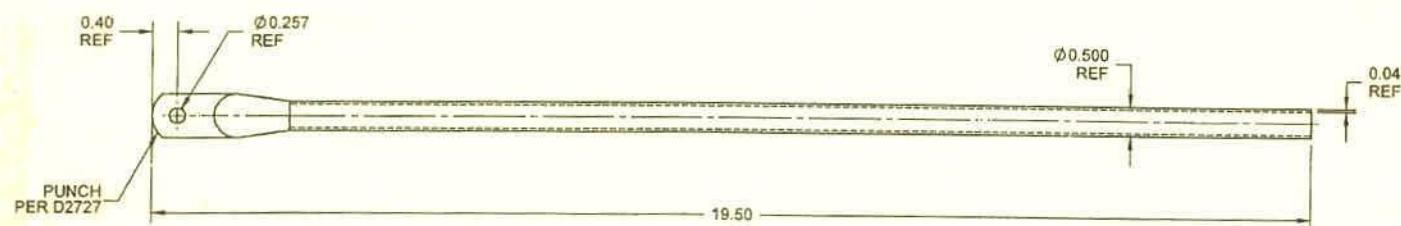
WJ 69(605)

RELEASED
08-07-23, 11:17

C	REDRAWN IN SOLIDWORKS; INCORPORATED REV. B1 (FINISH ADDED VIA HAND CHANGE) (ZN A6-2); ADD D2065F CUT LENGTH DETAIL FOR D2065 (ZN B3-2); ADD R1.50 DIMENSION (ZN D5-2). Ø 0.500 X 0.049 WALL WAS Ø 0.500 X 0.035 WALL (ZN A5-2); REASON: Ø 0.500 X 0.035 WALL TUBING USED ON D2010 IS CRACKING DURING SERVICE.	PH	08.06.13
B	RE-DESIGN	BW	96.02.06
A	NEW ISSUE	BW	92.03.12
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	DS	D2065	SHEET 1 OF 2
APPROVED	TS	TITLE	SCALE
DE APPR.	TS	ARM	NTS
DATE	08.06.13	COPYRIGHT © 1998 BY DART AEROSPACE LTD. THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. ANY USE OR DISSEMINATION IS EXPRESSLY PROHIBITED. PRINTED PERMISSION FROM DART AEROSPACE LTD.	



8 7 6 5 4 3 2 1

SECTION A-A

RELEASED
08.07.2018

NOTES:

- 1) MATERIAL: D2065F: AISI 304/316 SS SEAMLESS ROUND TUBING, Ø 0.500 X 0.049 WALL (REF BARF SPEC M304TR0.500W.049)
- 2) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.41 lbs
- 8) DRILL: Ø 0.188 AFTER BENDING

DESIGN	BW	DART AEROSPACE LTD
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA
CHECKED	AS	DRAWING NO.
MFG. APPR.	AS	REV. C
APPROVED	AS	D2065
DE APPR.	AS	SHEET 2 OF 2
DATE	08.06.13	TITLE
		SCALE
		NTS

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8 7 6 5 4 3 2 1

